


Date: Friday, 10/5/2007 8:14:47 AM
 User: Eric Charbonneau

Process Sheet

PROTOTYPE

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT BASE ASSY
 Job Number : 35017
 Estimate Number : 13043
 P.O. Number :
 This Issue : 10/5/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : 10/5/2007 Type : SMALL /MED FAB
 Previous Run :
 Written By : 
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-09-27 DD verified by:

Part Number : D3651041
 Drawing Number : D3651 UNDER REVIEW
 Project Number : N/A
 Drawing Revision : U/R
 Material :
 Due Date : 10/12/2007 Qty: 1 Um: Each

FOR ENGINEERING USE ONLY

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|-------------|-----------------------|
| 1.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

| | | |
|-----|--------|--------|
| 2.0 | D36511 | GASKET |
|-----|--------|--------|



CERTIFICATE OF CONFORMITY
 REQUIRED



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 GASKET

| | | |
|-----|--------|------|
| 3.0 | D36513 | BASE |
|-----|--------|------|



CERTIFICATE OF CONFORMITY
 REQUIRED



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 BASE

| | | |
|-----|--------|---------|
| 4.0 | D36519 | DOUBLER |
|-----|--------|---------|



CERTIFICATE OF CONFORMITY
 REQUIRED



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 DOUBLER

| | | |
|-----|---------|--------|
| 5.0 | D365111 | GASKET |
|-----|---------|--------|



CERTIFICATE OF CONFORMITY
 REQUIRED



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 GASKET

Date: Friday, 10/5/2007 8:14:47 AM
User: Eric Charbonneau

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE ASS'Y

Job Number: 35017

Part Number: D3651041

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

| | | |
|-----|---------|---------|
| 6.0 | D365113 | DOUBLER |
|-----|---------|---------|



CERTIFICATE OF CONFORMITY
REQUIRED



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
DOUBLER

| | | |
|-----|----------|-----------------|
| 7.0 | D3651043 | FLANGE ASSEMBLY |
|-----|----------|-----------------|



CERTIFICATE OF CONFORMITY
REQUIRED



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
FLANGE ASSEMBLY

| | | |
|-----|-------------|-------------------------------|
| 8.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D3651

| | | |
|-----|-----|------------------------------|
| 9.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|




ENGINEERING
APPROVAL



Comment: INSPECT WORK TO CURRENT STEP

| | | |
|------|-------------|-----------------------|
| 10.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|------|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1
Identify and Stock 
Location: _____

FOR ENGINEERING USE ONLY

| | | |
|------|------|------------------------------|
| 11.0 | QC21 | FINAL INSPECTION/W/O RELEASE |
|------|------|------------------------------|

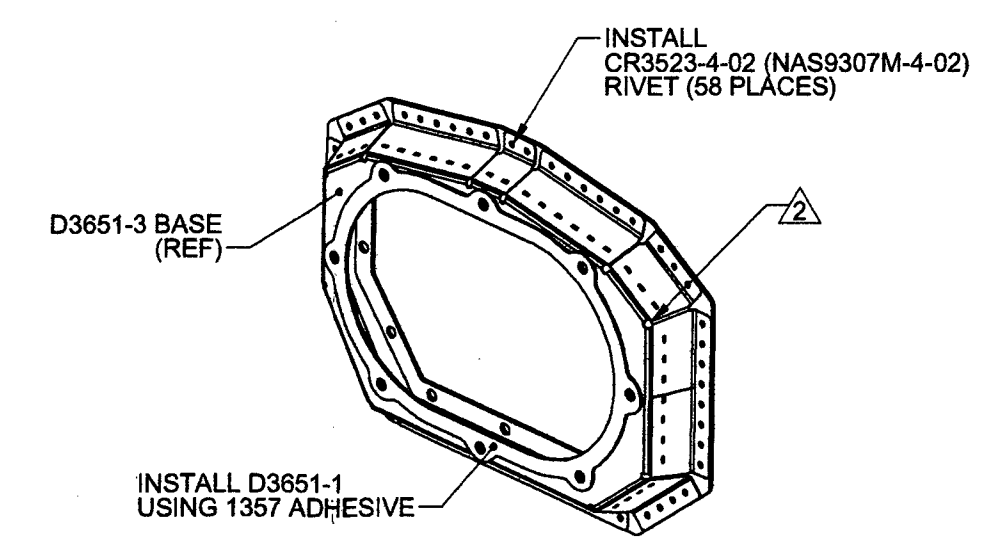
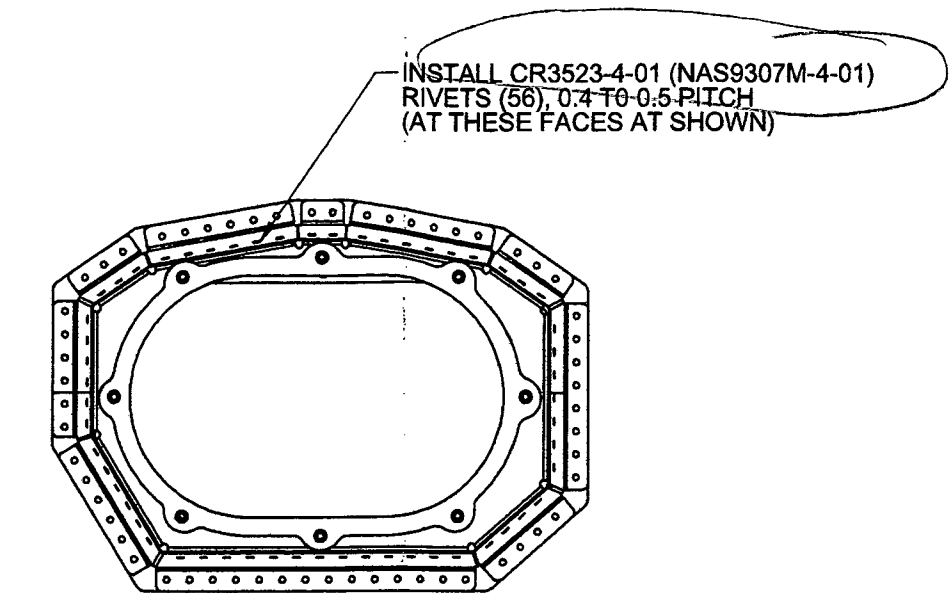
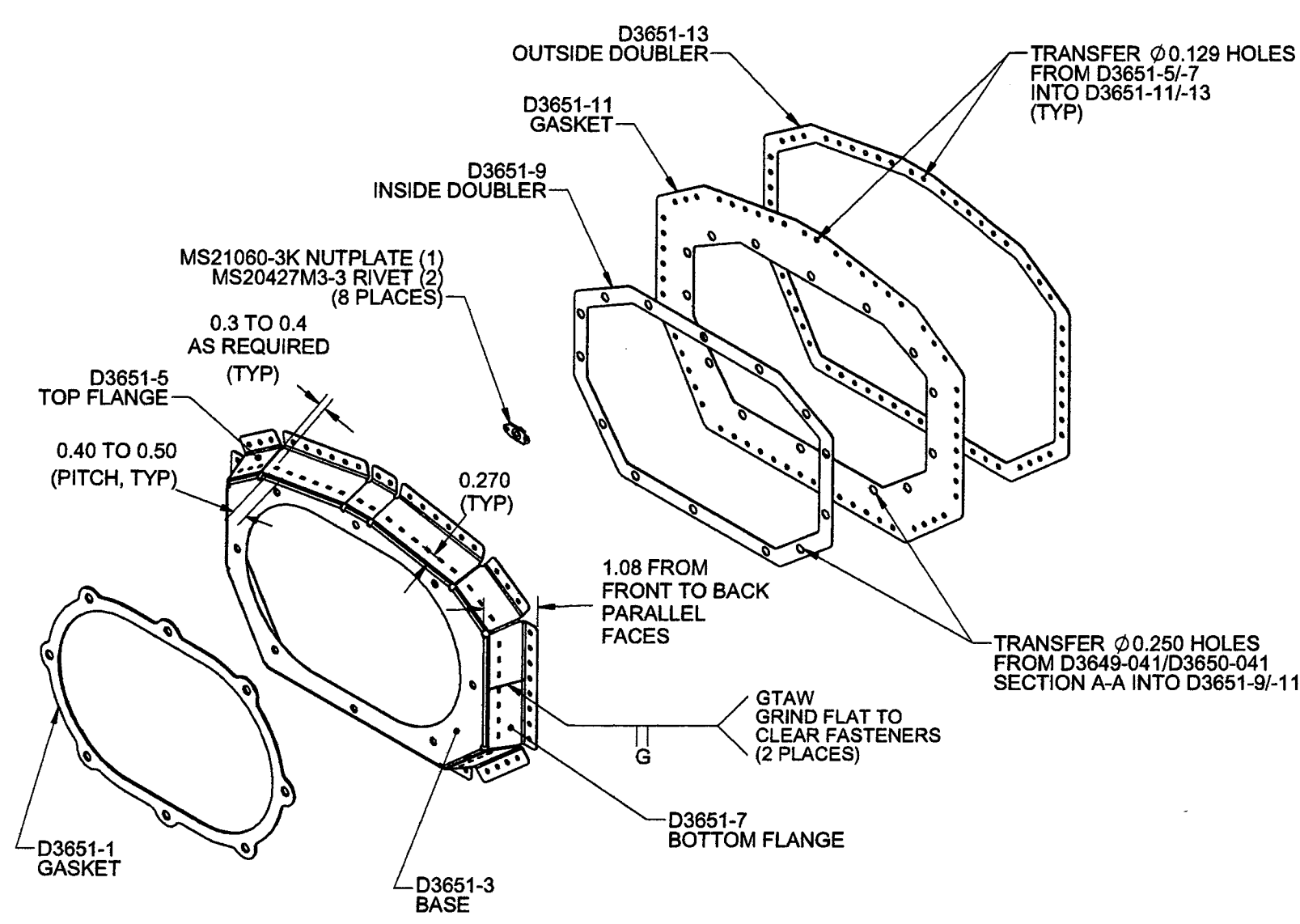


Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U.S. 11.26



D3651-041 AFT BASE ASSEMBLY

- NOTES:**
- 1) WELD PER QSI 004
 - 2) SEAL GAPS USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
 - 3) FINISH: NONE
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) ALL DIMENSIONS ARE IN INCHES
 - 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

| | | | |
|---|----------------|--|------------------------|
| A | 07.09.10 | NEW ISSUE | |
| DESIGN RF | DRAWN BY RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED DS | APPROVED | DRAWING NO. D3651 | REV. A SHEET 1 OF 5 |
| DATE 07.09.10 | | TITLE AFT BASE | SCALE 1:4 |
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